

Work Order ID 87797

87797

Page 1

July-12-12 9:02:26 AM

Item ID: D105-674-011G

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2966 | Rev A2 |

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D105-674-011G

CHG002

DAS 16

Handwritten: 12-7-25

130

0.00

130

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

** Pull D2966-1 bent **

- 1-Cut Aft end at 107.06" using DT8185D
- 2-Deburr ends
- 3-Drill Aft Cap holes using DT8678
- 4-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.
- 5-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.
- 6-Open Aft Cap holes using #6 drill
- 7-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.
- 8-Deburr holes.
- 9-Open remaining (16) crossbolt holes to Ø 1.00

①

Handwritten: SAD 12-07-12

B87797

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

87797

July-12-12 9:02:26 AM

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 7/12/12 **Start Qty:** 1.00 ***1***

Required Date: 7/20/12 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Item ID: D105-674-011G

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

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Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 180 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 190 | Skidtubes | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open crossbolt holes to finish size as per Dwg D2966 2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966 3-Deburr holes inside & outside, blow out chips | | | | | | | | |

2036

DP 12-7-17

DL 12/02/12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

200

0.00

200

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

A/R Sikaflex-291 batch: 122130

Sikaflex expiry date: 13-3-14

start time: 16:30

end time: 12-07-19

12/07/18

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

A/R Aluminum Rod batch: m120164

BE 12/07/19

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

4-Grind welds flush as per Dwg D2966

DP 12-7-19

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

DAS 16 9-5 12/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 87797

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July-12-12 9:02:26 AM

Item ID: D105-674-011G Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube, Grey
 Start Date: 7/12/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 225 | Touch up alodine | 0.00 | | | | | | | |
| *225* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 226 | Assemble as per dwg | 0.00 | | | | | | | |
| *226* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | ✓ INSTALL ALS7-1032-130, MS27039-1-08, AN960JD10L IN TWO PLACES BEFORE POWDERCOATING | | | | | | | | |

DAS 16 7/26/19

1X 0 M-F 12/07/19

1X 0 M 12/07/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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July-12-12 9:02:26 AM

Item ID: D105-674-011G

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| Powdercoat | | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |
| | Memo | | | | | | | | |
| | START TIME: 2:00 | | | | | | | | |
| | OVEN TEMPERATURE: 320 F | | | | | | | | |
| | FINISH TIME: 2:30 | | | | | | | | |
| 240 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | | 0.00 | | | | | | | |
| Quality Control | Memo | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 87797

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July-12-12 9:02:26 AM

Item ID: D105-674-011G

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 250 | HandFinishing | 0.00 | | | | | | | |
| *250* | HandFinish | 0.00 | | | | 1 x | 0 | 94-1104123 | |
| Hand Finishing | Memo | | | | | | | | |
| | 1-Inspect for foreign objects as per QSI 024 | | | | | | | | |
| | 2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side. | | | | | | | | |
| | Pick: | | | | | | | | |
| | QtyPart NumberDescriptionBatch | | | | | | | | |
| | A/RSikaflex-291 11121531 | | | | | | | | |
| | Sikaflex expiry date: 12/08 | | | | | | | | |
| | 3-Wing Walk as per Dwg D2966 and QSI 005 4.4 | | | | | | | | |
| | Batch: _____ | | | | | | | | |
| 260 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *260* | QC | 0.00 | | | | | | | |
| Quality Control | Memo | | | | | | | | |

1x 6 94-01-03

DAS
16 17/6/12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D105-674-011G Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube, Grey
 Start Date: 7/12/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270 *270* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo *****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966***** | 0.00 0.00 | | | | | | | |
| 280 *280* Packaging Packaging | Pick Kit Memo | 0.00 0.00 | | | | 1 | | | 1707/25AB |
| 290 *290* QC Quality Control | QC4- 100% Inspect kits for completeness Memo | 0.00 0.00 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D105-674-011G

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Setup Start ***NS1***

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Item Name: Skidtube, Grey

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 300 | Packaging | 0.00 | | | | | | | |
| *300* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D105-674-011G Location: _____ | | | | | | | | |
| 310 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *310* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6/12/12

12/7/30

*MUF
12-07-27*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

July-12-12 9:02:26 AM

Page 1

Work Order ID: 87797
Parent Item: D105-674-011G
Parent Item Name: Skidtube, Grey

Start Date: 7/12/12 Required Date: 7/20/12
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A04.07.07New IssueKJ/JLM IPP Rev:B 10.06.09 remove seq110 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2966-1-BENT Skidtube Assembly 105 | | Manufactured | No | | | 130 | Each | 2.0000 | 1 | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG | | 2 | | | | | | | |
| | | | | 83295 | | 1 | | | | | | | |
| | | | | 83783 | | 1 | | | | | | | |
| D2964 Cap | | Manufactured | No | | | 140 | Each | 29.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG | | 12 | | | | | | | |
| | | | | 83064 | | 12 | | | | | | | |
| | | | | LG002 | | 17 | | | | | | | |
| | | | | 74719 | | 17 | | | | | | | |
| D2976 BO 105 Skidtube I Beam | | Manufactured | No | | | 200 | Each | 0.0000 | 1 | 1 | | | |
| D2971 Cross Bolt Spacer | | Manufactured | No | | | 200 | Each | 22.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG001 | | 22 | | | | | | | |
| | | | | 74720 | | 22 | | | | | | | |
| D2973 Cross Bolt Spacer | | Manufactured | No | | | 200 | Each | 64.0000 | 7 | 7 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG002 | | 64 | | | | | | | |
| | | | | 14636 | | 14 | | | | | | | |
| | | | | 80092 | | 50 | | | | | | | |

SAD 1207/12

BE 12/07/10

PL 12/07/18
BE 12/07/19

BE 12/07/19

7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

July-12-12 9:02:26 AM

Page 2

Work Order ID: 87797

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

D2965
Cap, 105 Skidtube

*

Manufactured No

250 Each 44.0000

1387959 (x1) 1 11 11/07/12

Location

Loc Qty

Loc Code

FP002

44

71371

4

80089

40

D2970-1
Wearplate

Manufactured No

250 Each 8.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

FP001

8

48213

3

80090

5

D2970-3
Wearplate

Manufactured No

250 Each 9.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

FP001

1

48214

1

FP002

8

80091

8

D3176-1
Bushing

Manufactured No

250 Each 6.0000

1 (x1) 1 11 11/07/12

Location

Loc Qty

Loc Code

ST032

6

37586

6

D3176-3
Nut

Manufactured No

250 Each 9.0000

1 11 11/07/12

Location

Loc Qty

Loc Code

ST032

9

44896

9

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Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 87797

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

250

Each

1,520.0000

36

Insert

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

1469

119530

73

120181

12

121444

1384

36 36 11/07/12

MS27039-1-08

Purchased

No

250

Each

1,168.0000

26

Screw

Location

Loc Qty

Loc Code

ST291

1168

117423

81

119075

1

120308

166

121011

43

121243

500

121708

377

26 26 11/07/12

AN960JD10L

NAS1149D0332J

Purchased

No

250

Each

0.0000

28

Washer

X

11121011

28 28 11/07/12

MS27039-1-09

Purchased

No

250

Each

267.0000

2

Screw

Location

Loc Qty

Loc Code

FP002

93

18057

93

ST291

174

111650

174

2 2 11/07/12

VZ

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 87797

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | | | |
|------------------------|--------------|----|-----------------|----------------|-----------------|----------|--------|---|----|----------|
| S D2972 Bushings | Manufactured | No | | 290 | Each | 27.0000 | 6 | 6 | JB | |
| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | ST022 | 27 | | | | | | |
| | | | 33544 | 4 | | | | | | |
| | | | 44160 | 23 | | | | | | |
| | | | | | | | 44160 | | | |
| S D2974 Packer | Manufactured | No | | 290 | Each | 37.0000 | 1 | 1 | JB | |
| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | ST022 | 37 | | | | | | |
| | | | 71997 | 37 | | | | | | |
| | | | | | | | 71997 | | | |
| S D2975 Wearshoe | Manufactured | No | | 290 | Each | 4.0000 | 2 | 2 | JB | |
| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | ST497A | 2 | | | | | | |
| | | | 74721 | 2 | | | | | | |
| | | | ST500 | 2 | | | | | | |
| | | | 80093 | 2 | | | | | | |
| | | | | | | | 74721 | | | |
| S AN4-51A Bolt | Purchased | No | | 290 | Each | 526.0000 | 3 | 3 | JB | |
| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | 362 | 96 | | | | | | |
| | | | 121181 | 96 | | | | | | |
| | | | ST361 | 430 | | | | | | |
| | | | 119798 | 30 | | | | | | |
| | | | 122151 | 400 | | | | | | |
| | | | | | | | 122151 | | | |
| S AN960JD10L Washer | Purchased | No | | 290 | Each | 0.0000 | 8 | 8 | JB | 12/07/25 |
| | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | NAS1149D0332J | | | | | | | |
| | | | | | | | 121708 | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 87797

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

S MS21042L4
Nut

Purchased

No

290

Each

914.0000

3

3

✓ JB

Location

Loc Qty

Loc Code

ST300

914

119075

116

121011

193

121444

605

121444

S MS27039-1-08

Screw

Purchased

No

290

Each

1,168.0000

8

8

122452 ✓ JB 12/07/12

Location

Loc Qty

Loc Code

ST291

1168

117423

81

119075

1

120308

166

121011

43

121243

500

121708

377

July-12-12 9:02:26 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|---------------------|-----------------------|---|------------------------|
| DESIGN <i>RF</i> | DRAWN BY <i>RF</i> | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D2966 | REV. A SHEET 1 OF 2 |
| DATE 00.03.08 | | TITLE BO 105 SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 00.03.08 | NEW ISSUE | |

RELEASED
00.05.11 *#*

46728



| Qty | Part Number | Description |
|-----|---|-------------------|
| X | D2966-041 | SKIDTUBE ASSEMBLY |
| 1 | D2962-125 | EXTRUSION |
| 1 | D2964 | CAP |
| 1 | D2965 | CAP |
| 1 | D2970-1 | WEARPLATE |
| 1 | D2970-3 | WEARPLATE |
| 1 | D2971 | CROSS BOLT SPACER |
| 7 | D2973 | CROSS BOLT SPACER |
| 1 | D2976 | WEB |
| 36 | ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130 | INSERT |
| 28 | AN960JD10L | WASHER |
| 26 | MS27039-1-08 | SCREW |
| 2 | MS27039-1-09 | SCREW |
| 1 | D3176-1 | BUSHING |
| 1 | D3176-3 | NUT |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.24
(P 01.01.30)

| | | | |
|----|----------|-------------------------------|--------------------|
| A2 | 02.10.30 | ADD D3176-1/-3 | <i>#</i> <i>UP</i> |
| A1 | 01.01.24 | CHANGE COLOR TO BLACK SANDTEX | <i>#</i> <i>UP</i> |

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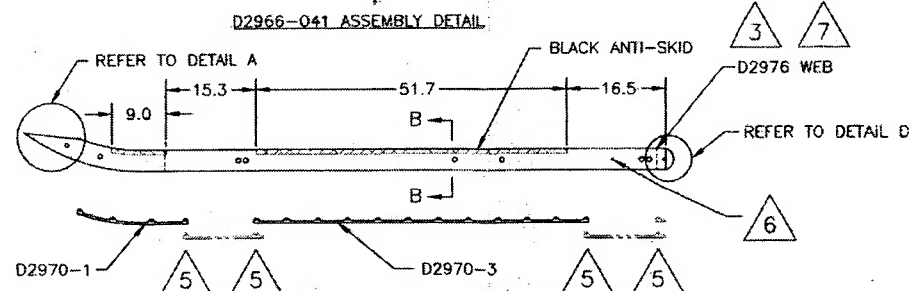
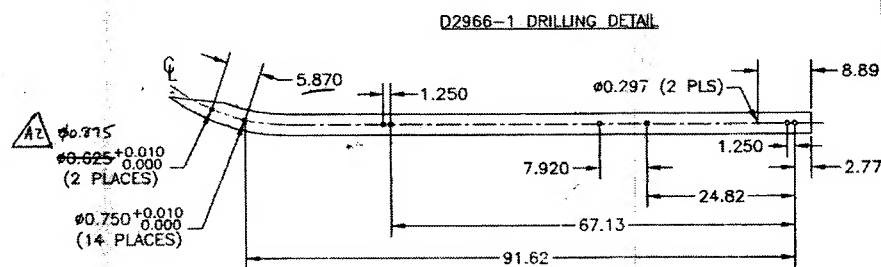
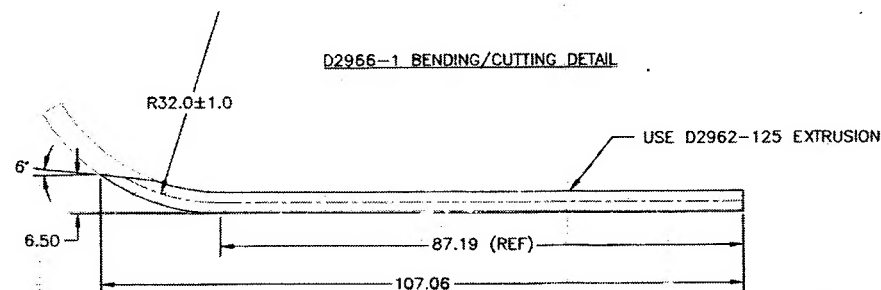
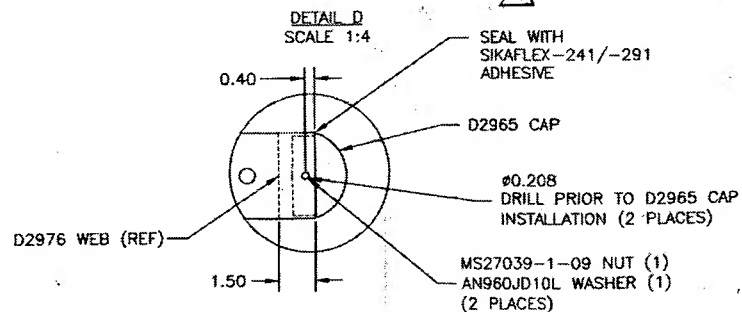
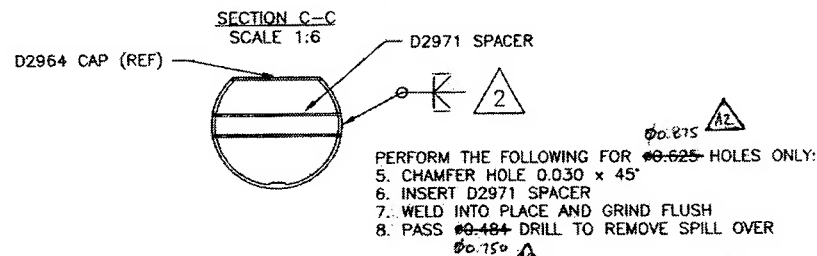
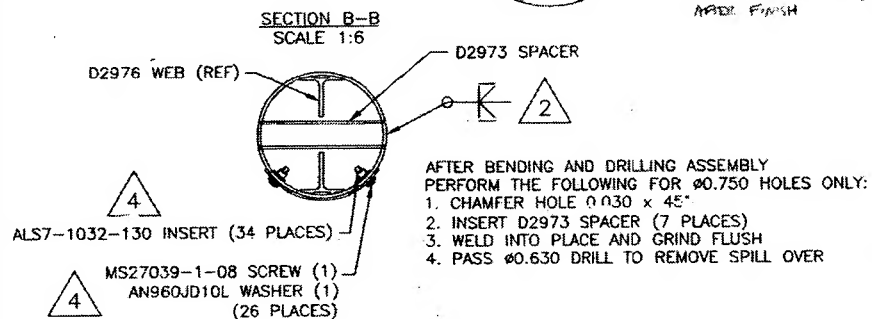
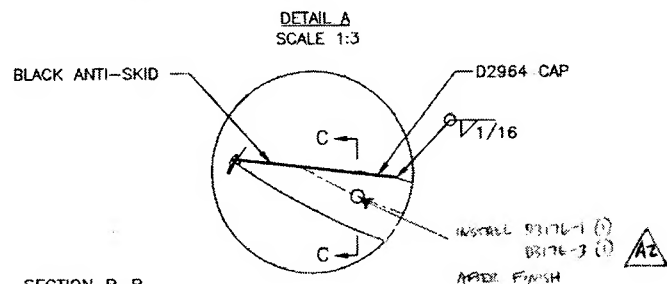
Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries



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DESIGN
RF

CHECKED
A

DATE
00.03.08

DRAWN BY
RF

APPROVED
A

DART DART AEROSPACE USA, INC.
BELLEVUE, WA

DRAWING NO.
D2966

TITLE
BO 105 SKIDTUBE ASSEMBLY

REV. A

SHEET 2 OF 2

SCALE
1:20

RELEASED
00-05-11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

NO. 259

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B68574
Part number: D105-674-0116
Description: 10S
Welding Process: Tig~~h~~ Mig~~h~~ ☐
Base material: Aluminum
Current: AC~~h~~ DC~~h~~ ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐
pass~~h~~ fail~~h~~ ☐

Qualifier Sal Davis Date of Test Coupon 11.06.30
Welder Barclay Elliott Date of Test Coupon 11.06.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld